

Item	Qty -203	Part Number	Description
1	X	D412-596-203	CROSSTUBE ASSEMBLY (412 HI HI AFT)
2	1	D6020-170	CROSSTUBE MATERIAL
3	2	D3595-063-530	RUBBER CUSHION
4	1	D4909-1	SUPPORT
5	2	D4910-1	CHAFING SHIELD
7	4	MS21920-26	CLAMP
8	2	MS21920-28	CLAMP
9	A/R	SCOTCH-WELD DP460	EPOXY ADHESIVE, 3M SCOTCH-WELD
10	A/R	PROSEAL 890	SEALANT

**GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6020-170  
FINISHED LENGTH = 151.38±0.060 (BEFORE BENDING/TRIMMING)
- 2) FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART P/N "D412-596-203" AND B/N ON INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 191.1 lb RAW MATERIAL, 118.3 lb AFTER MACHINING  
116.0 lb FINISHED WEIGHT
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

**BENDING**

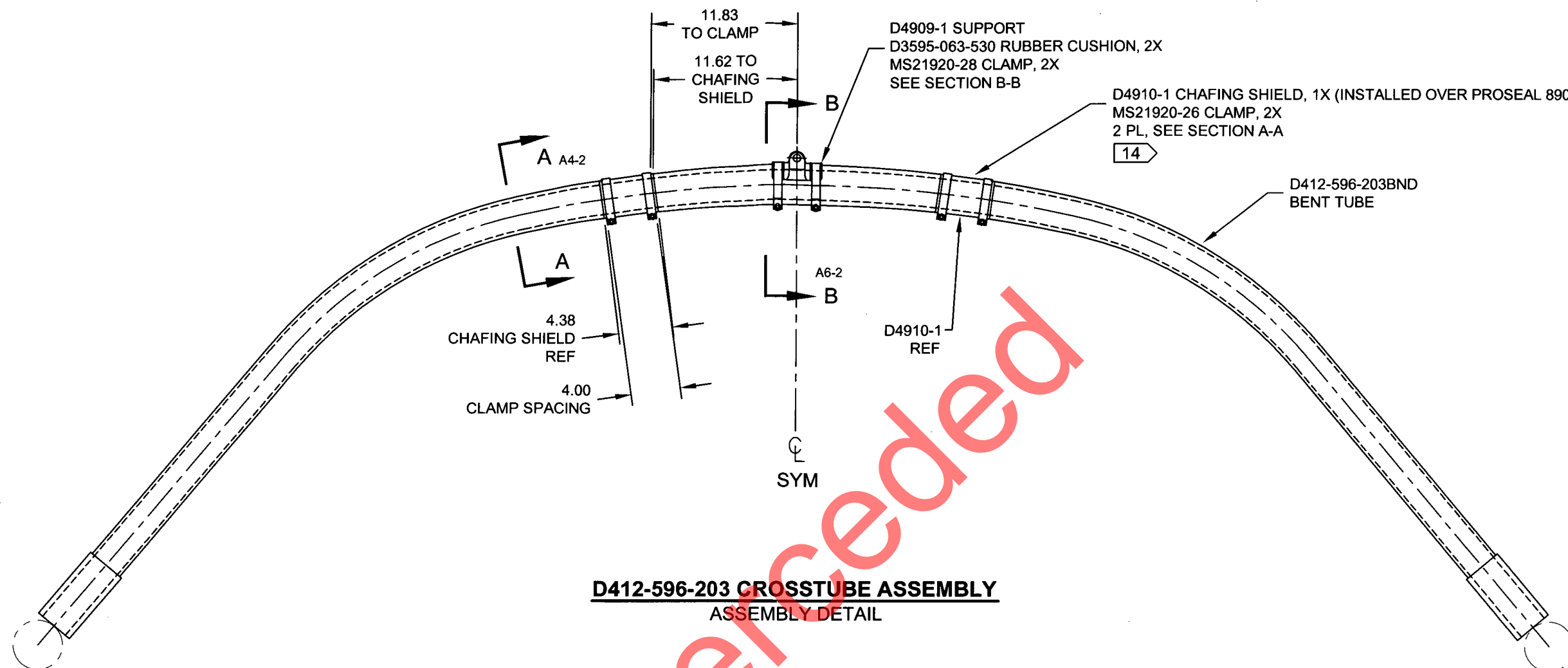
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 7% (BASED ON O.D.) IN LOWER HALF OF R35 BEND AND 6% (BASED ON O.D.) ON REMAINING TUBE.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038. TO BE PERFORMED AFTER FINAL POST-BEND GRINDING. ANY ADDITIONAL GRINDING REQUIRES ANOTHER LPI INSPECTION.

**ASSEMBLY**

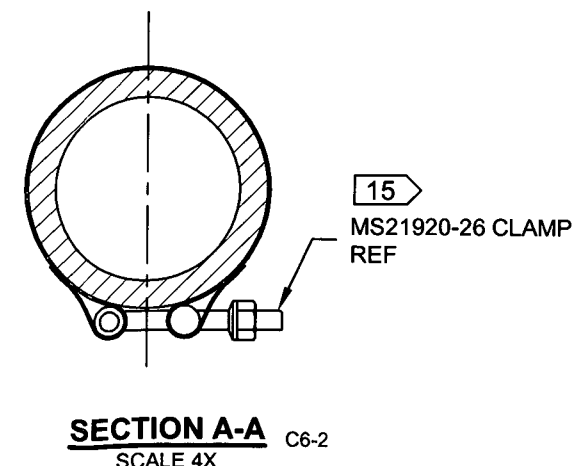
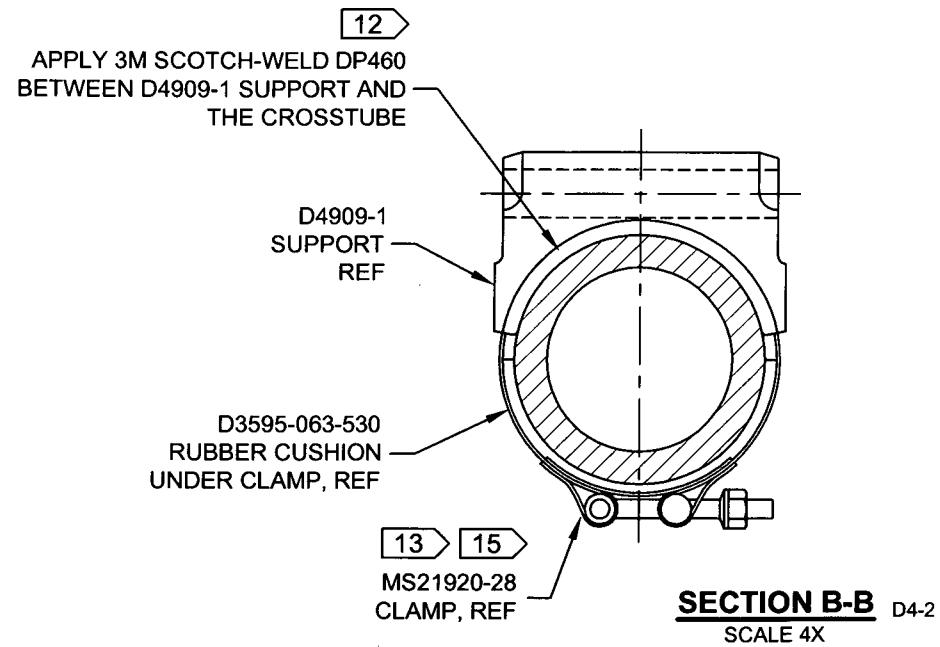
- 12) INSTALL D4909-1 CENTER SUPPORT USING A 0.04" TO 0.07" THICK LAYER OF SCOTCH-WELD DP460 PER QSI 015.
- 13) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D4909-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) IF NOT ALREADY PRESENT ON CHAFING SHIELD, APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D4910-1 CHAFING SHIELD AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL PROSEALED D4910-1 CHAFING SHIELD ONTO CROSSTUBE BY APPLYING A THIN COAT OF PROSEAL 890 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.
- 15) TORQUE CLAMPS ON D4909-1 SUPPORT 80 TO 100 IN-LB. TORQUE CLAMPS ON D4910-1 CHAFING SHIELD 40 TO 50 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVES HAVE CURED FOR 24 HOURS.

RELEASED  
2013-08-06

A	NEW ISSUE	CP	13.03.13
REV.	DESCRIPTION	BY	DATE
DESIGN	qp	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	qp		
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	AP	D412-596-203	SHEET 1 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	CROSSTUBE ASSY (412 HI HI AFT)	NTS
DATE	13.03.13	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

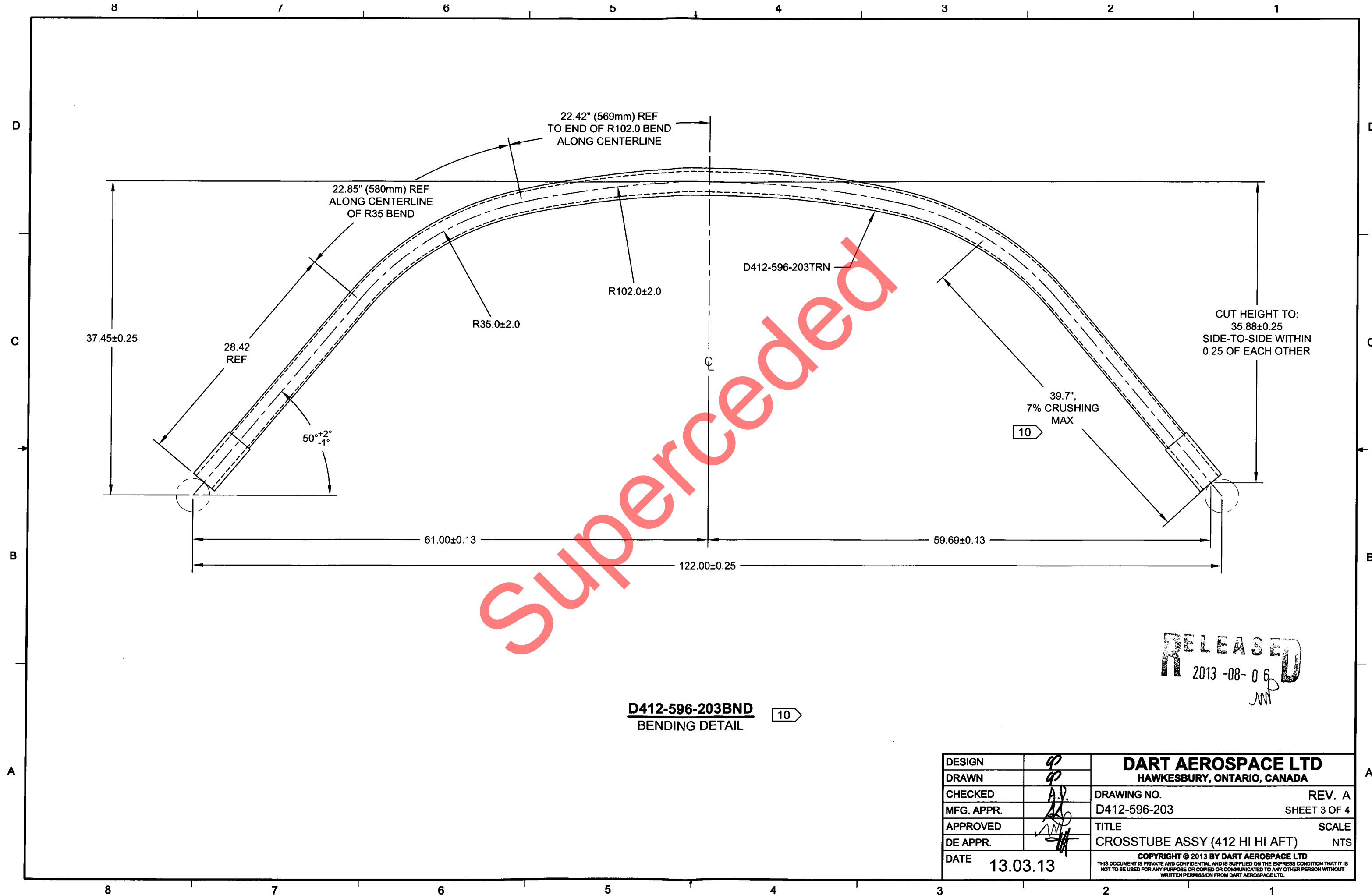


**D412-596-203 CROSSTUBE ASSEMBLY**  
ASSEMBLY DETAIL

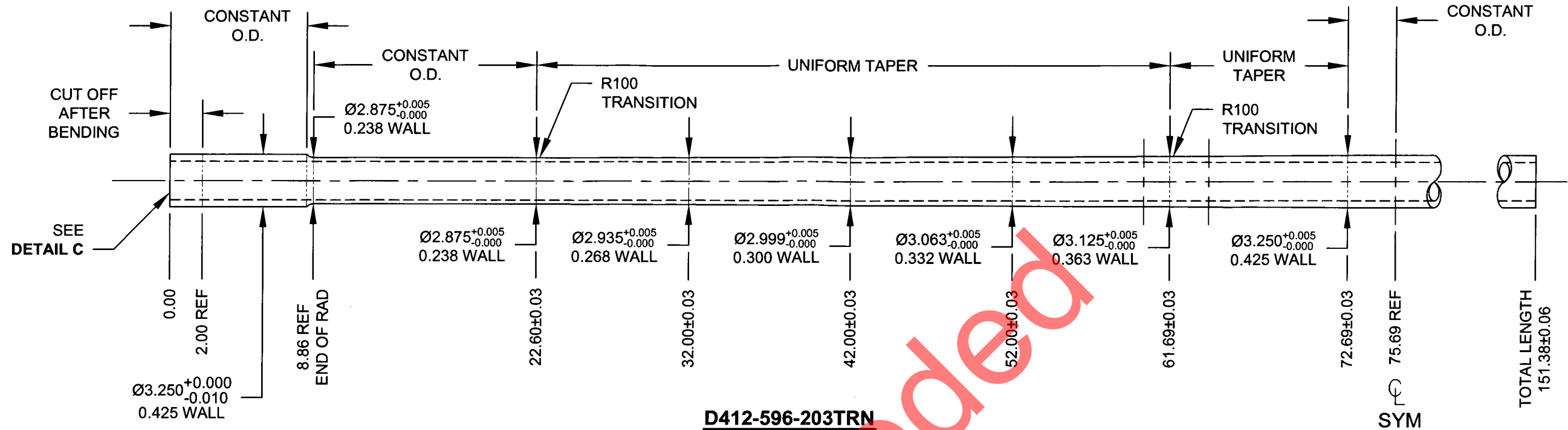


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2013-08-06

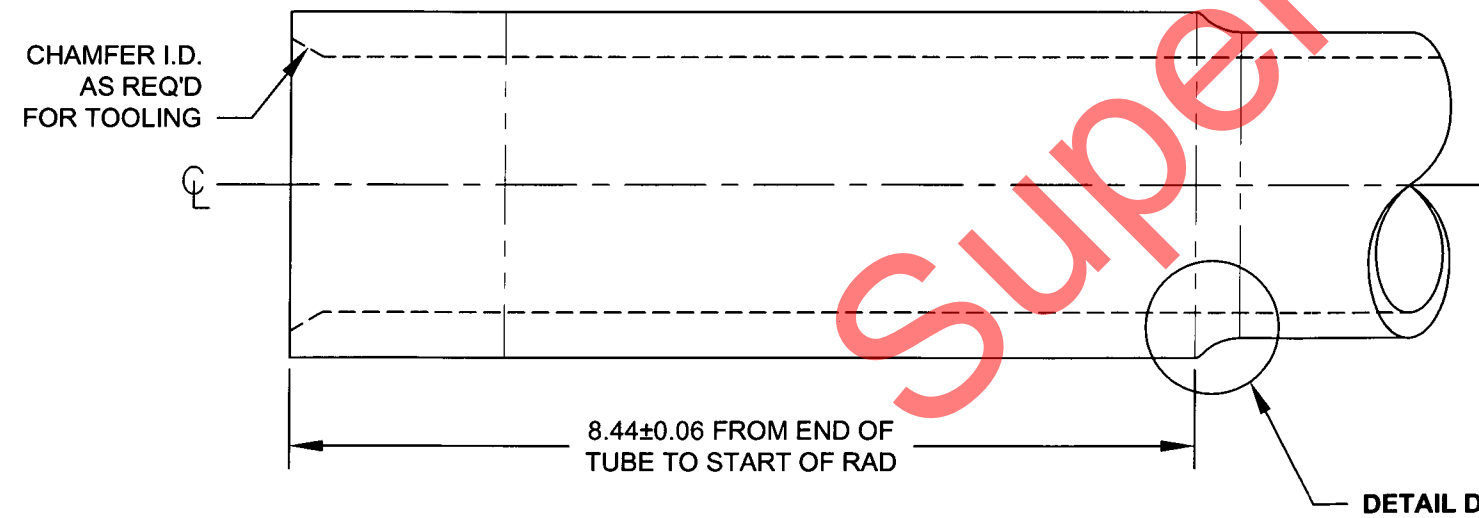
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DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.R.	DRAWING NO.	REV. A
MFG. APPR.	NA	D412-596-203	SHEET 2 OF 4
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	CROSSTUBE ASSY (412 HI HI AFT)	NTS
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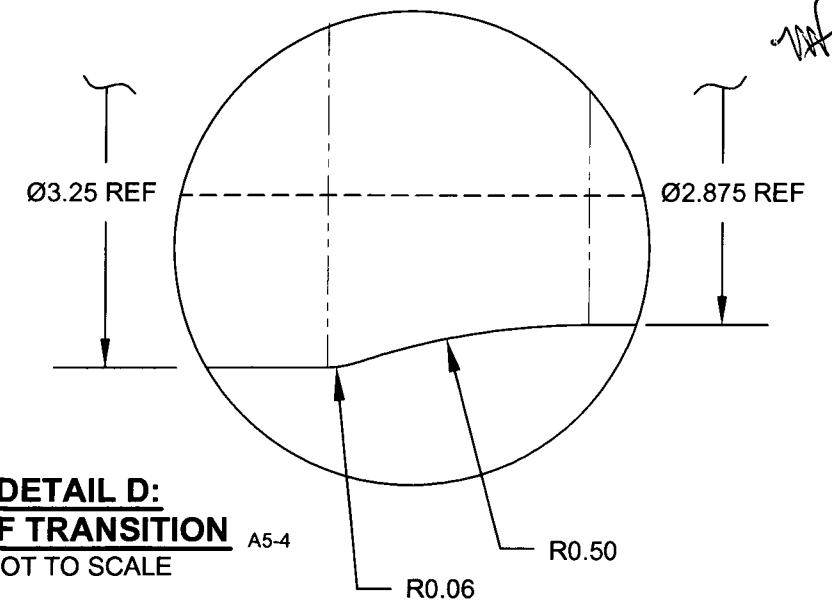
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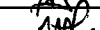
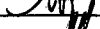


**D412-596-203TRN**  
TURNING DETAIL



**DETAIL C:**  
**CUFF TRANSITION** C8-4  
SCALE 4X



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DRAWN	90		
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.		D412-596-203	SHEET 4 OF 4
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